



900

NOTES:
1) THOROUGHLY CLEAN AND DEGREASE ALL PART SURFACES BEFORE WELDING PER FERMILAB APPROVED PROCEDURE.

- 2) NOTE 1/2 HOLE SPACE ROTATIONAL POSITION ON ALL THREE WELD FLANGES, IT.#6, #11 AND #15.
- 3) ALL WELDS MUST BE VACUUM TIGHT. ALL WELDS WILL BE TESTED BY VENDOR USING A LEAK DETECTOR WITH A MINIMUM SENSITIVITY OF 2 x 10^-9 TORR-LITER/SEC OF HELIUM. ALL WELDS SHALL BE SPRAYED WITH HELIUM WITH NO DETECTABLE LEAK.
- 4) THE FINISHED VESSEL SHALL BE THOROGHLY CLEANED AND DEGREASED PER FERMILAB APPROVED PROCEDURE. CLEANED VESSEL MUST BE FREE OF ALL MILL SCALE, RUST, WELD RESIDUE, WELD SPLATTER, GREASE, OIL, MOISTURE, AND OTHER DEBRIS. EXCEPT WHERE NOTED, THE VESSEL INTERO SURFACES SHALL BE PRIMED WITH AEROGLAZE 9958 PRIMER, AND PAINTED WITH AEROGLAZE 2-306 FLAT BLACK, IN ACCORDANCE WITH MANUFACTURER'S RECOMMENDED PROCEDURES AND THICKNESSES. EXCEPT WHERE NOTED, THE VESSEL EXTERIOR SURFACES SHALL BE PRIMED AND PAINTED IN ACCORDANCE WITH THE VENDOR'S STANDARD PROCEDURES.

15	MA-393267		ISO-LF320 WELD FLANGE			1
14	MA-393	262	ISO-LF250 BOLT KIT			1
13	MA-393261		ISO-LF250 SEAL ASSEMBLY			1
12	MA-393260		ISO-LF250 BLANK FLANGE			1
11	MA-393	259	ISO-LF250 WELD FLANGE			1
10	MA-393	258	ISO-LF500 BOLT KIT			1
9	MA-393	257	ISO-LF500 SEAL ASSEMBLY			1
8	MA-393	256	ISO-LF500 BLANK FLANGE			1
7	MC-424	055	12.75° PORT TUBE			1
6	MC-424	054	MOD-ISO-LF500 WELD FLNG			1
5	MC-424	053	10 PORT TUBE			1
4	MB-424	048	RING MOUNTING BLOCK			8
3	MC-424047		PMT FLANGE #2			64
2	MC-424046		18 PORT TUBE			1
1	ME-424038		SMALL WELDMENT-MACHINED			1
ITEM	PART NO.		DESCRIPTION OR SIZE			QTY.
			PARTS LI	ST		
UNLESS OTHERWISE SPECIFIE			on one on	G. APOLL I NAR I	$\perp$	
.XX	.xxx	ANGLES	DRAWN	G.ZIELBAUER		17/03
± .04  ±.010 ± 2*		_	CHECKED	J.BRANDT	9/	17/03
1. 889	MAX,	EDGES	APPROVED			
2. DO NOT SCALE DRAWING,			USED ON 5520-ME-4240			36

ISO-LF320 BOLT KIT

17 MA-393269 ISO-LF320 SEAL ASSEMBLY 16 MA-393268 ISO-LF320 BLANK FLANGE 1

3. DURMENIOR SEED UPON ANSI 1714, 594-1982
4. MAX. ALL MACH. SURFACES MATERIAL SEE ABOVE

18 MA-393270

FERMI NATIONAL ACCELERATOR LABORATORY

CKM VACUUM VETO SYSTEM SMALL FINAL ASSEMBLY
SMALL WELDMENT - COMPLETE SCALE FILMED DRAWING NUMBER 5520-ME-424037

DEAS 8m4 USER NAME: brand